

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025641**Date Inspected:** 03-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

SHIP # 19, OBG SEGMENT 14E

This Quality Assurance Inspector (QA) performed Visual Testing (VT) review of randomly selected welds and base metal of Side Panel, Bottom Panel, Edge Panel and Deck Panel located on OBG segment 14E. The following issue(s) have been noted.

Weld joint joining horizontal stiffener plate X4762K to brace plate X4752B on vertical shear plate SA3365A at PP 126 welded with steel backing bar. The steel backing bar is observed as tack welded. As per shop drawing and weld details this weld is shown as Partial Joint Penetration (PJP).

Weld joint joining horizontal stiffener plate X4762H to brace plate X4749E on vertical shear plate SA3363A at PP 126 welded with steel backing bar. The steel backing bar is observed as tack welded and the gap between backing bar and component is observed as approx 8mm. As per shop drawing and weld details this weld is shown as Partial Joint Penetration (PJP).

Weld joint joining horizontal stiffener plate X4762G to brace plate X4749D on vertical shear plate SA3362A at PP

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126 welded with steel backing bar. The steel backing bar is observed as tack welded. As per shop drawing and weld details this weld is shown as Partial Joint Penetration (PJP).

Cracked tack observed on weld joints joining following parts.

Anchorage connection plates X4763B and X4764B to vertical shear plate SA3358A.

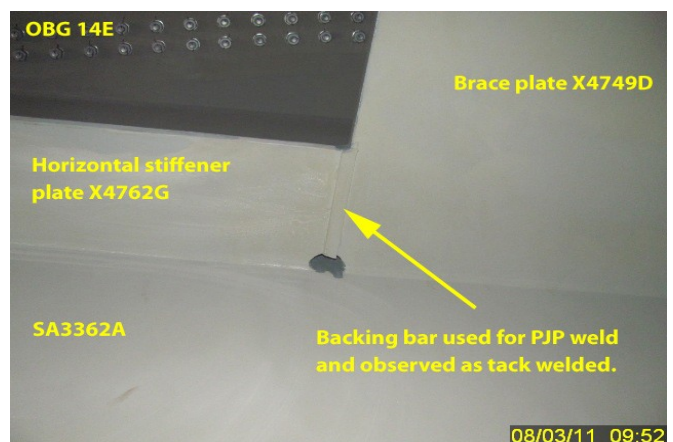
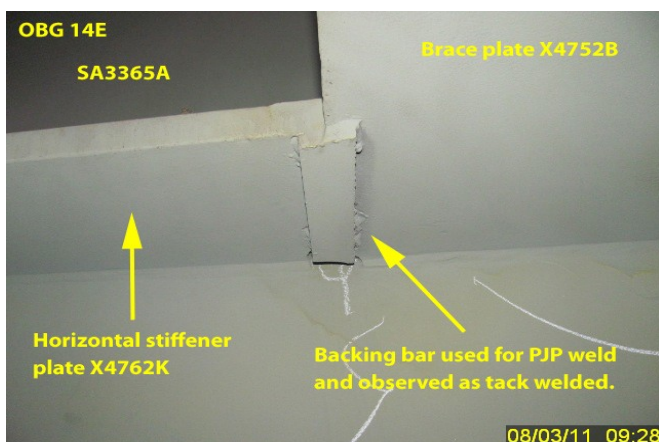
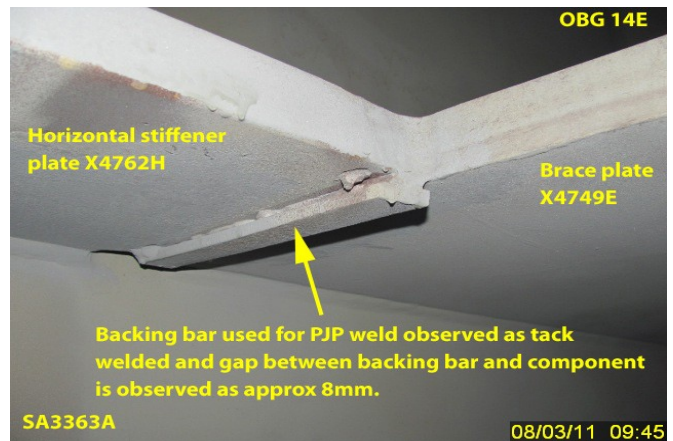
Anchorage connection plate X4764C to vertical shear plate SA3359A.

Anchorage connection plates X4763D and X4764D to vertical shear plate SA3360A.

Anchorage connection plate X4764F to vertical shear plate SA3362A.

See attached photographs for more details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
